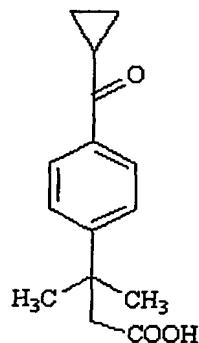


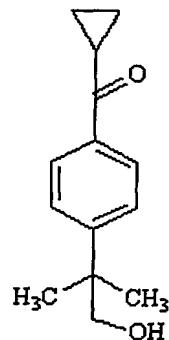
## WE CLAIM:

1 1. A process for the preparation of cyclopropyl keto  $\alpha$ ,  $\alpha$ -dimethylphenyl acetic acid  
2 of Formula I,



## FORMULA I

3 the process comprising treating 4-(cyclopropylmethoxy)-2,2-dimethylphenethyl  
4 alcohol of Formula III,



## FORMULA III

5 with a hydroxide of an alkali metal; adding oxidizing agent followed by aqueous  
6 acidic work up; and isolating the cyclopropyl keto  $\alpha$ ,  $\alpha$ -dimethylphenyl acetic acid.

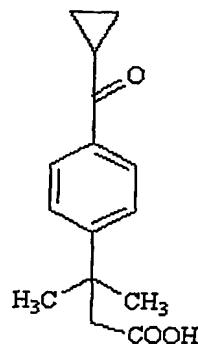
1 2. The process of claim 1, wherein the hydroxide of an alkali metal is lithium  
2 hydroxide, sodium hydroxide, and potassium hydroxide.

1 3. The process of claim 2, wherein the hydroxide of an alkali metal is sodium  
2 hydroxide.

1 4. The process of claim 1, wherein the oxidizing agent is potassium permanganate.

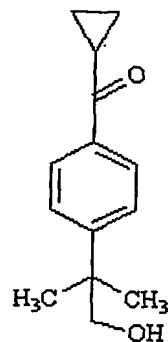
1 5. The process of claim 1, wherein the oxidizing agent is added in small lots.

1 6. A process for the preparation of cyclopropyl keto  $\alpha$ ,  $\alpha$ -dimethylphenyl acetic acid  
2 of Formula I,



### FORMULA I

3 the process comprising treating 4-(cyclopropyloxomethyl)-2,2-dimethylphenethyl  
4 alcohol of Formula III,

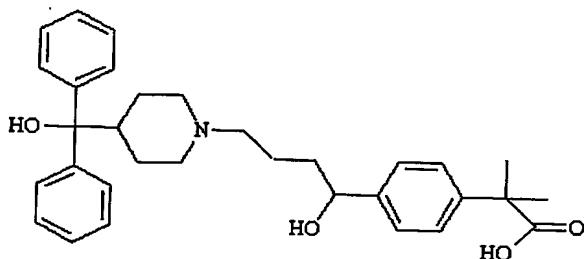


### FORMULA III

5 with a hydroxide of an alkali metal; adding oxidizing agent; adding organic solvent  
6 followed by aqueous acidic work up; and isolating the cyclopropyl keto  $\alpha$ ,  $\alpha$ -  
7 dimethylphenyl acetic acid.

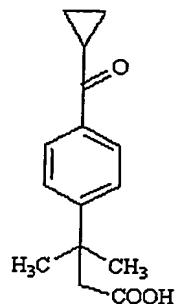
1 7. The process of claim 6, wherein the hydroxide of an alkali metal is lithium  
2 hydroxide, sodium hydroxide, and potassium hydroxide.

- 1 8. The process of claim 7, wherein the hydroxide of an alkali metal is sodium  
2 hydroxide.
- 1 9. The process of claim 6, wherein the oxidizing agent is potassium permanganate.
- 1 10. The process of claim 6, wherein the oxidizing agent is added in small lots.
- 1 11. The process of claim 6, wherein the organic solvent comprises one or more of  
2 chlorinated hydrocarbon, ketone, or mixtures thereof.
- 1 12. The process of claim 11, wherein the ketone comprises one or more of acetone,  
2 methyl ethyl ketone, and methyl isobutyl ketone.
- 1 13. The process of claim 12, wherein the ketone is acetone.
- 1 14. The process of claim 11, wherein the chlorinated hydrocarbon comprises one or  
2 more of dichloromethane, chloroform, and 1,2-dichloroethane.
- 1 15. The process of claim 6, further comprising removing precipitated inorganic solids  
2 after adding organic solvent.
- 1 16. The process of claim 15, wherein the inorganic solids are removed by filtration.
- 1 17. The process of claim 16, further comprising washing filtrate with one or more of a  
2 chlorinated solvent after removal of the inorganic solids.
- 1 18. The process of claim 17, wherein the chlorinated hydrocarbon comprises one or  
2 more of dichloromethane, chloroform, and 1,2-dichloroethane.
- 1 19. A process for the preparation of fexofenadine of Formula II or a pharmaceutically  
2 acceptable salt thereof,



FORMULA II

3        the process comprising hydrolyzing the cyclopropyl keto  $\alpha$ ,  $\alpha$ -dimethylphenyl  
4        acetic acid of Formula I prepared by the process of claim 1 or 6, condensing with



5        FORMULA I

5        azacyclonol, and reducing.

1        20.    A method of treating allergic reactions in a patient in need thereof, the method  
2        comprising providing a dosage form to said patient that includes fexofenadine  
3        hydrochloride prepared by the process of claim 19.